

## Assembly and installation

### a) Installation position

Glandless Norgren valves can be installed in any position unless specified in the data sheet. Bistable 5/2-way valves have a mechanical detent. When installing a valve, the possible contamination of the valve and its connections, the accessibility of the manual override, the pilot exhaust air holes, etc. should be taken into account.

### b) Tightening torque of the fastening screws

It is usually sufficient to tighten the fastening screws by hand. In order to avoid damage to the threaded holes due to over-tightening, the following values should not be exceeded.

Products	Thread	Maximum tightening torque
Mounting screws MIDI*STAR Valve	M4	2.4 Nm
Mounting screws ISO*STAR size 1 Valve	M5	3.1 Nm
Mounting screws ISO*STAR size 2 Valve	M6	3.5 Nm
Mounting screws ISO*STAR size 3 Valve	M8	5.6 Nm
Mounting screws MULTI*STAR Base plate	M5	3.1 Nm
Fixing nut for coil		1.1 Nm